

Work Order ID 84750

May-22-12 2:59:58 PM

*Ship July 31*

\*84750\*

Page 1

Item ID: D3602-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Angle

Stop \*NS2\*

Start Date: 22/05/2012 Start Qty: 6.00

\*6\*

Cust Item ID:

Required Date: 05/06/2012 Req'd Qty: 6.00

\*6\*

Customer:

Reference:

Approvals:

Process Plan: ML5

Date: 12/05/22

Tooling:

Date:         

Run Start \*NR1\*

QC:

Date:         

SPC (Y/N):

Date:         

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3602

Rev B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3602

Dwg Rev: B

Prog Rev: B 2-

Deburr if necessary

384 .040

6 0 Jim  
12-6-6

110

0.00

\*110\*

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

6 0 Jim  
12-6-6

120

0.00

\*120\*

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

6 0 WJ  
12-06-07

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

## Packaging

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**Accept**

**\*N900040100\***

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Revision ID:

**Item Name:** Angle

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**Start Date:** 22/05/2012    **Start Qty:** 6.00

\*6\*

**Cust Item ID:**

**Required Date:** 05/06/2012      **Req'd Qty:** 6.00

\*6\*

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/  
Work Center ID

### Operation Description

### Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

MLJ 12/07/30

MS 12107130

**Dart Aerospace Ltd**

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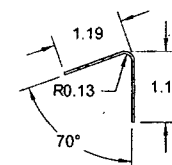
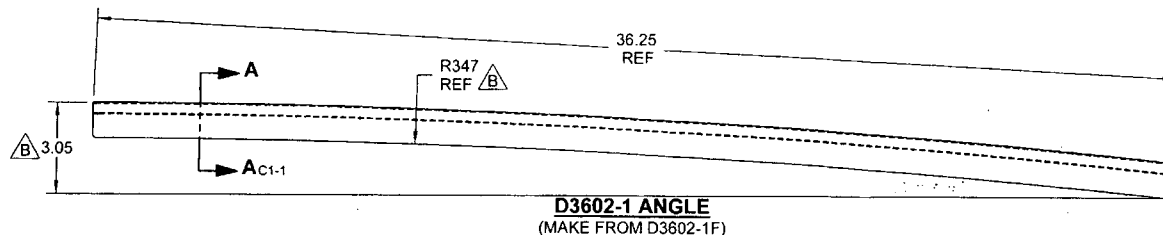
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SECTION A-A C7-1  
SCALE 2X

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 84750 MWS

12/05/22

RELEASED  
6/23/11 MWS

D3602-1F FLAT PATTERN

R0.13  
TYP

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.97 lbs

B	ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014	MB	09.02.02
A	NEW ISSUE	MB	07.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.02		

DART AEROSPACE LTD  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3602

TITLE

ANGLE

REV. B

SHEET 1 OF 1

SCALE

NTS

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